

Claims

1. A numerical control apparatus for making the contour control by controlling two or more control axes, characterized by comprising chopping movement data generating means for generating the movement data for making the chopping operation by controlling said two or more control axes at the same time.

2. A numerical control apparatus for making the contour control by controlling two or more control axes, characterized by comprising chopping movement data generating means for generating the movement data for making the chopping operation by controlling said two or more control axes at the same time while making the contour control.

3. The numerical control apparatus according to claim 2, characterized in that said chopping movement data generating means generates the movement data for making the chopping operation for said control axes at the same time while making the contour control in such a manner as to convolute the movement data for making the chopping operation and the movement data for making the contour control, and distribute said convoluted data to each of said control axes.

4. The numerical control apparatus according to claim 2 or 3, characterized by further comprising correction means for correcting a servo delay of each control axis to make the chopping operation at the same time while making the contour control.

5. The numerical control apparatus according to claim 4, characterized in that said correction means corrects a servo delay of each of two or more control axes to make the chopping operation at the same time while making the contour control in such a manner as to acquire a servo delay amount of each control axis by comparing the actual position feedback information for each control axis making the chopping operation at the same time while making the contour control with a command value, synthesize said acquired servo delay amount of each control axis, and distribute said synthesized servo delay amount to a chopping interpolation vector and a contour control interpolation vector.

6. The numerical control apparatus according to claim 1 or 2, characterized in that a chopping operation initiation command and a chopping operation stop command are issued from any one of a processing program and a ladder portion.

7. The numerical control apparatus according to claim 1 or 2, characterized in that various data regarding the chopping operation command are set as the parameters in a memory, and when the chopping operation initiation command is issued, the chopping control is performed using various data regarding the chopping operation command set as said parameters.